

Work Order ID 74538

Tuesday, October 04, 2011 8:21:38 AM



Page 1

Item ID: D3213-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Panel

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3213

B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3213 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

2024 .063

B11-10-29

20

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-10-29

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11 10 31 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D3213-1

Accept



Setup Start



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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Debur

20 BL 11-1-1

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Hand Finishing

20X PM 11/11/01

150



QC

QC3- Inspect Part Finish

Memo

0.00

0.00

Quality Control

11/11/01 (20)

Dart Aerospace Ltd

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Tuesday, October 04, 2011 8:21:38 AM

Page 3



Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation	Description
1	Start of the program
2	Initial values of the variables
3	Calculation of the first term of the series
4	Calculation of the second term of the series
5	Calculation of the third term of the series
6	Calculation of the fourth term of the series
7	Calculation of the fifth term of the series
8	Calculation of the sixth term of the series
9	Calculation of the seventh term of the series
10	Calculation of the eighth term of the series
11	Calculation of the ninth term of the series
12	Calculation of the tenth term of the series
13	Calculation of the eleventh term of the series
14	Calculation of the twelfth term of the series
15	Calculation of the thirteenth term of the series
16	Calculation of the fourteenth term of the series
17	Calculation of the fifteenth term of the series
18	Calculation of the sixteenth term of the series
19	Calculation of the seventeenth term of the series
20	Calculation of the eighteenth term of the series
21	Calculation of the nineteenth term of the series
22	Calculation of the twentieth term of the series
23	Calculation of the twenty-first term of the series
24	Calculation of the twenty-second term of the series
25	Calculation of the twenty-third term of the series
26	Calculation of the twenty-fourth term of the series
27	Calculation of the twenty-fifth term of the series
28	Calculation of the twenty-sixth term of the series
29	Calculation of the twenty-seventh term of the series
30	Calculation of the twenty-eighth term of the series
31	Calculation of the twenty-ninth term of the series
32	Calculation of the thirtieth term of the series
33	Calculation of the thirty-first term of the series
34	Calculation of the thirty-second term of the series
35	Calculation of the thirty-third term of the series
36	Calculation of the thirty-fourth term of the series
37	Calculation of the thirty-fifth term of the series
38	Calculation of the thirty-sixth term of the series
39	Calculation of the thirty-seventh term of the series
40	Calculation of the thirty-eighth term of the series
41	Calculation of the thirty-ninth term of the series
42	Calculation of the fortieth term of the series
43	Calculation of the forty-first term of the series
44	Calculation of the forty-second term of the series
45	Calculation of the forty-third term of the series
46	Calculation of the forty-fourth term of the series
47	Calculation of the forty-fifth term of the series
48	Calculation of the forty-sixth term of the series
49	Calculation of the forty-seventh term of the series
50	Calculation of the forty-eighth term of the series
51	Calculation of the forty-ninth term of the series
52	Calculation of the fiftieth term of the series
53	Calculation of the fifty-first term of the series
54	Calculation of the fifty-second term of the series
55	Calculation of the fifty-third term of the series
56	Calculation of the fifty-fourth term of the series
57	Calculation of the fifty-fifth term of the series
58	Calculation of the fifty-sixth term of the series
59	Calculation of the fifty-seventh term of the series
60	Calculation of the fifty-eighth term of the series
61	Calculation of the fifty-ninth term of the series
62	Calculation of the sixtieth term of the series
63	Calculation of the sixty-first term of the series
64	Calculation of the sixty-second term of the series
65	Calculation of the sixty-third term of the series
66	Calculation of the sixty-fourth term of the series
67	Calculation of the sixty-fifth term of the series
68	Calculation of the sixty-sixth term of the series
69	Calculation of the sixty-seventh term of the series
70	Calculation of the sixty-eighth term of the series
71	Calculation of the sixty-ninth term of the series
72	Calculation of the seventieth term of the series
73	Calculation of the seventy-first term of the series
74	Calculation of the seventy-second term of the series
75	Calculation of the seventy-third term of the series
76	Calculation of the seventy-fourth term of the series
77	Calculation of the seventy-fifth term of the series
78	Calculation of the seventy-sixth term of the series
79	Calculation of the seventy-seventh term of the series
80	Calculation of the seventy-eighth term of the series
81	Calculation of the seventy-ninth term of the series
82	Calculation of the eightieth term of the series
83	Calculation of the eighty-first term of the series
84	Calculation of the eighty-second term of the series
85	Calculation of the eighty-third term of the series
86	Calculation of the eighty-fourth term of the series
87	Calculation of the eighty-fifth term of the series
88	Calculation of the eighty-sixth term of the series
89	Calculation of the eighty-seventh term of the series
90	Calculation of the eighty-eighth term of the series
91	Calculation of the eighty-ninth term of the series
92	Calculation of the ninetieth term of the series
93	Calculation of the ninety-first term of the series
94	Calculation of the ninety-second term of the series
95	Calculation of the ninety-third term of the series
96	Calculation of the ninety-fourth term of the series
97	Calculation of the ninety-fifth term of the series
98	Calculation of the ninety-sixth term of the series
99	Calculation of the ninety-seventh term of the series
100	Calculation of the ninety-eighth term of the series
101	Calculation of the ninety-ninth term of the series
102	Calculation of the hundredth term of the series
103	Calculation of the hundred and first term of the series
104	Calculation of the hundred and second term of the series
105	Calculation of the hundred and third term of the series
106	Calculation of the hundred and fourth term of the series
107	Calculation of the hundred and fifth term of the series
108	Calculation of the hundred and sixth term of the series
109	Calculation of the hundred and seventh term of the series
110	Calculation of the hundred and eighth term of the series
111	Calculation of the hundred and ninth term of the series
112	Calculation of the hundred and tenth term of the series
113	Calculation of the hundred and eleventh term of the series
114	Calculation of the hundred and twelfth term of the series
115	Calculation of the hundred and thirteenth term of the series
116	Calculation of the hundred and fourteenth term of the series
117	Calculation of the hundred and fifteenth term of the series
118	Calculation of the hundred and sixteenth term of the series
119	Calculation of the hundred and seventeenth term of the series
120	Calculation of the hundred and eighteenth term of the series
121	Calculation of the hundred and nineteenth term of the series
122	Calculation of the hundred and twentieth term of the series
123	Calculation of the hundred and twenty-first term of the series
124	Calculation of the hundred and twenty-second term of the series
125	Calculation of the hundred and twenty-third term of the series
126	Calculation of the hundred and twenty-fourth term of the series
127	Calculation of the hundred and twenty-fifth term of the series
128	Calculation of the hundred and twenty-sixth term of the series

Set Up/ Run Hours

Tool ID**Tool #**

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

Identify as per dwg & Stock Location: 232A

0.00

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release


0.00

QC

Memo

0.00

Quality Control

11/11/01 

MF
11-11-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 04, 2011 8:21:44 AM

Page 1

Work Order ID: 74538



Parent Item: D3213-1



Parent Item Name: Door Panel



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 05-11-17 New Issue JLM
IPP Rev:B 07-02-13 Now on Waterjet JLM
IPP Rev C: 08.11.26 Comment added to step 2 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 		Purchased	No			100	sf	115.5000	0.4714	4.962105			
2024-T3 .063 sheet													

B1110-09

Location

Loc Qty

Loc Code

MAT022

115.5

117392

115.5

117392

20

Dart Aerospace Ltd

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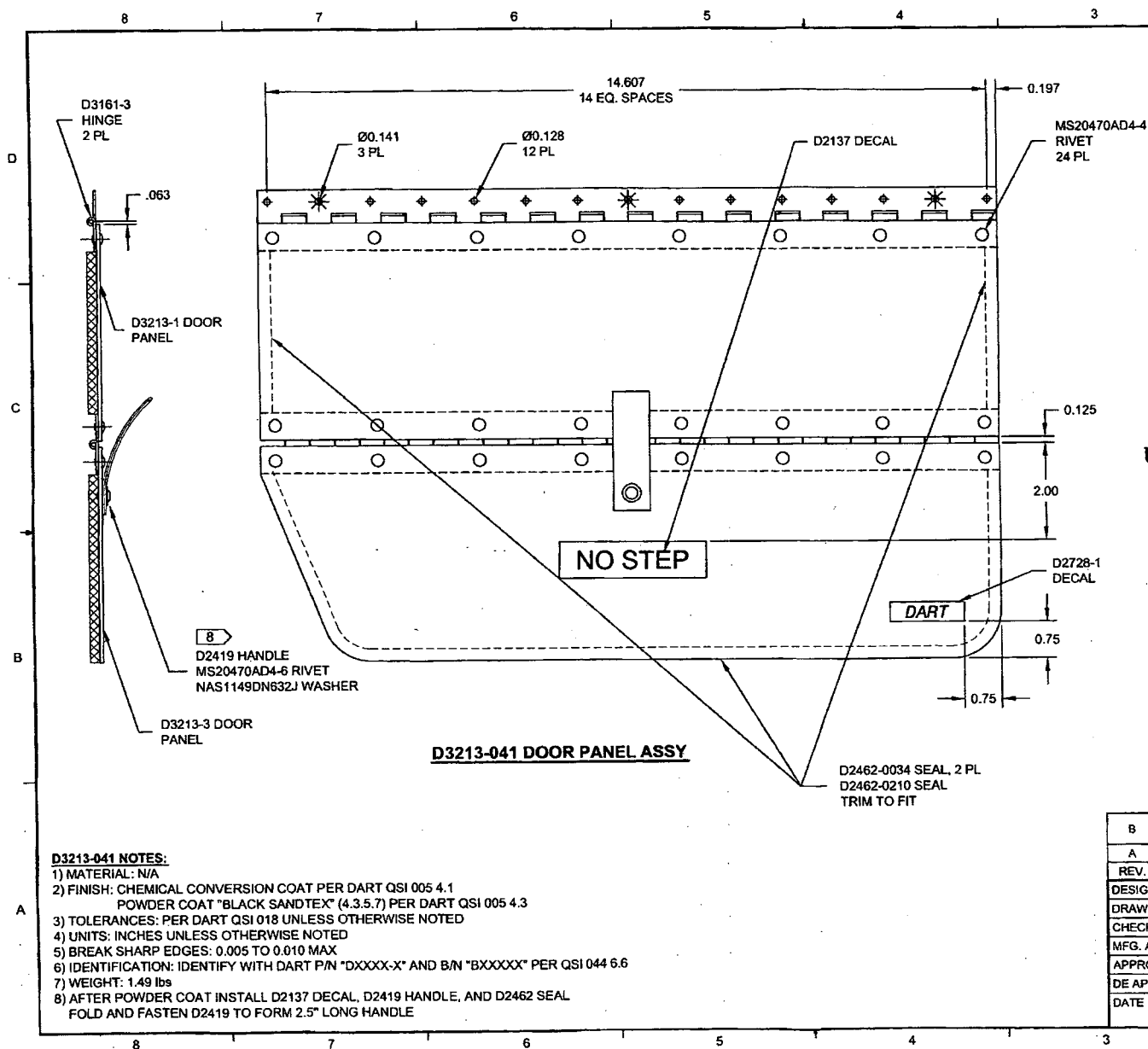
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QTY	PART NUMBER	DESCRIPTION
-041		
X	D3213-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74538 M.L.J

11/10/04

RELEASED
2011-06-10

B	FORMAT TO CURRENT STD; ADD D3213-041B REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>		
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	11.06.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3213
TITLE DOOR ASSEMBLY
REV. B
SHEET 1 OF 4
SCALE NTS

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Dart Aerospace Ltd

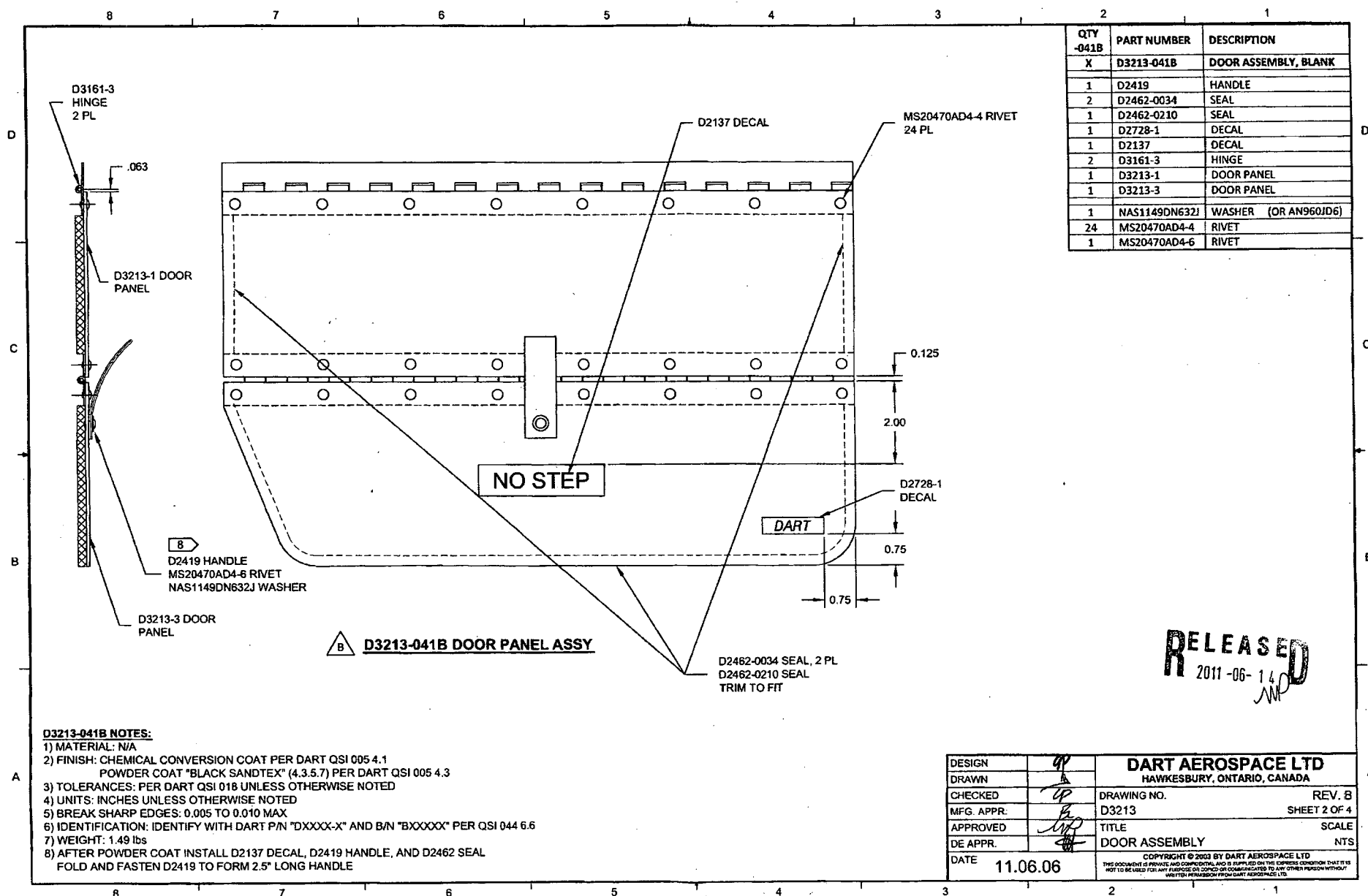
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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74538



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

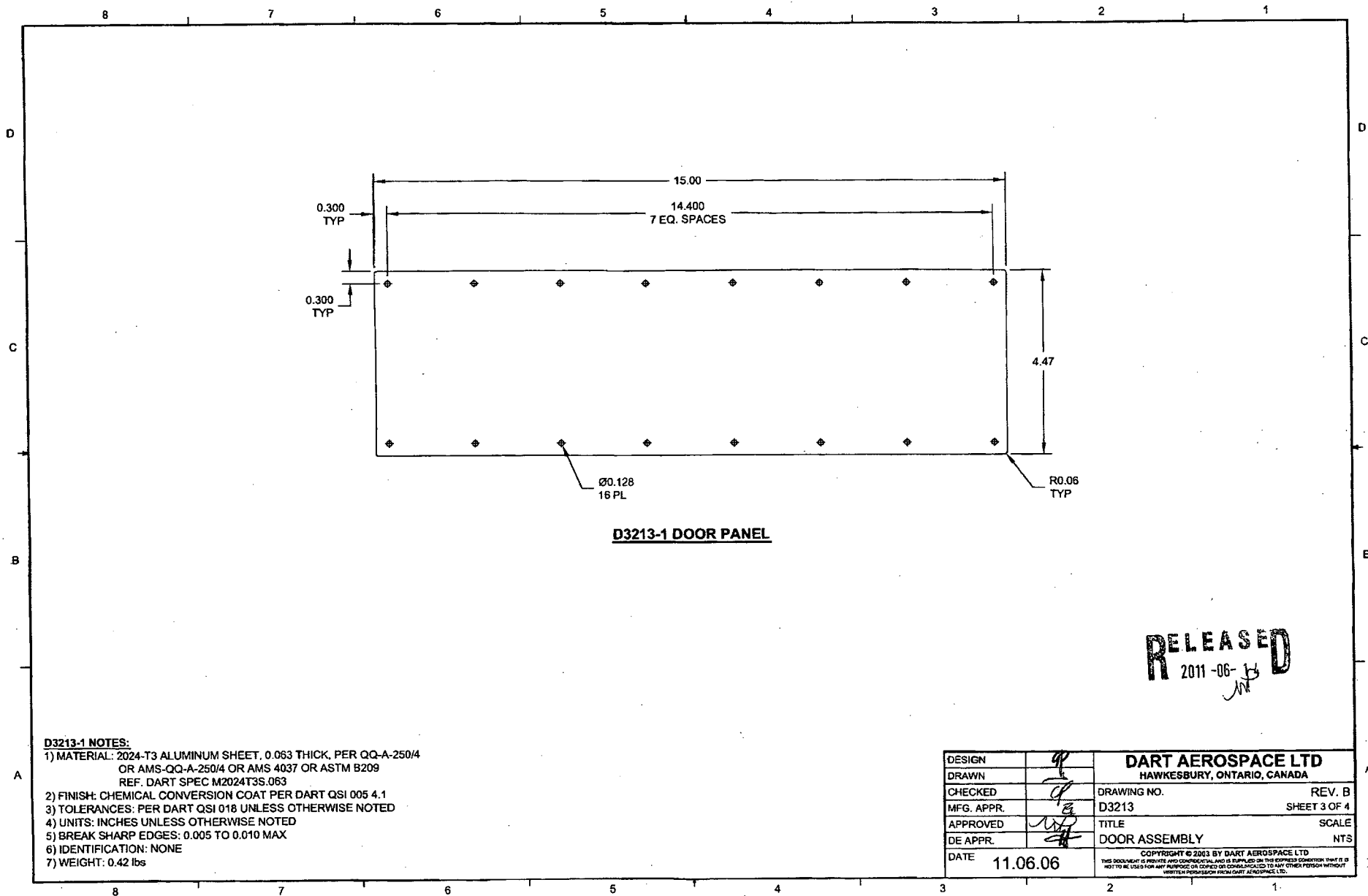
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NOTE: Date & initial all entries

74538



D3213-1 DOOR PANEL

RELEASED
2011-06-13

D3213-1 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3213	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOOR ASSEMBLY	NTS
DATE	11.06.06	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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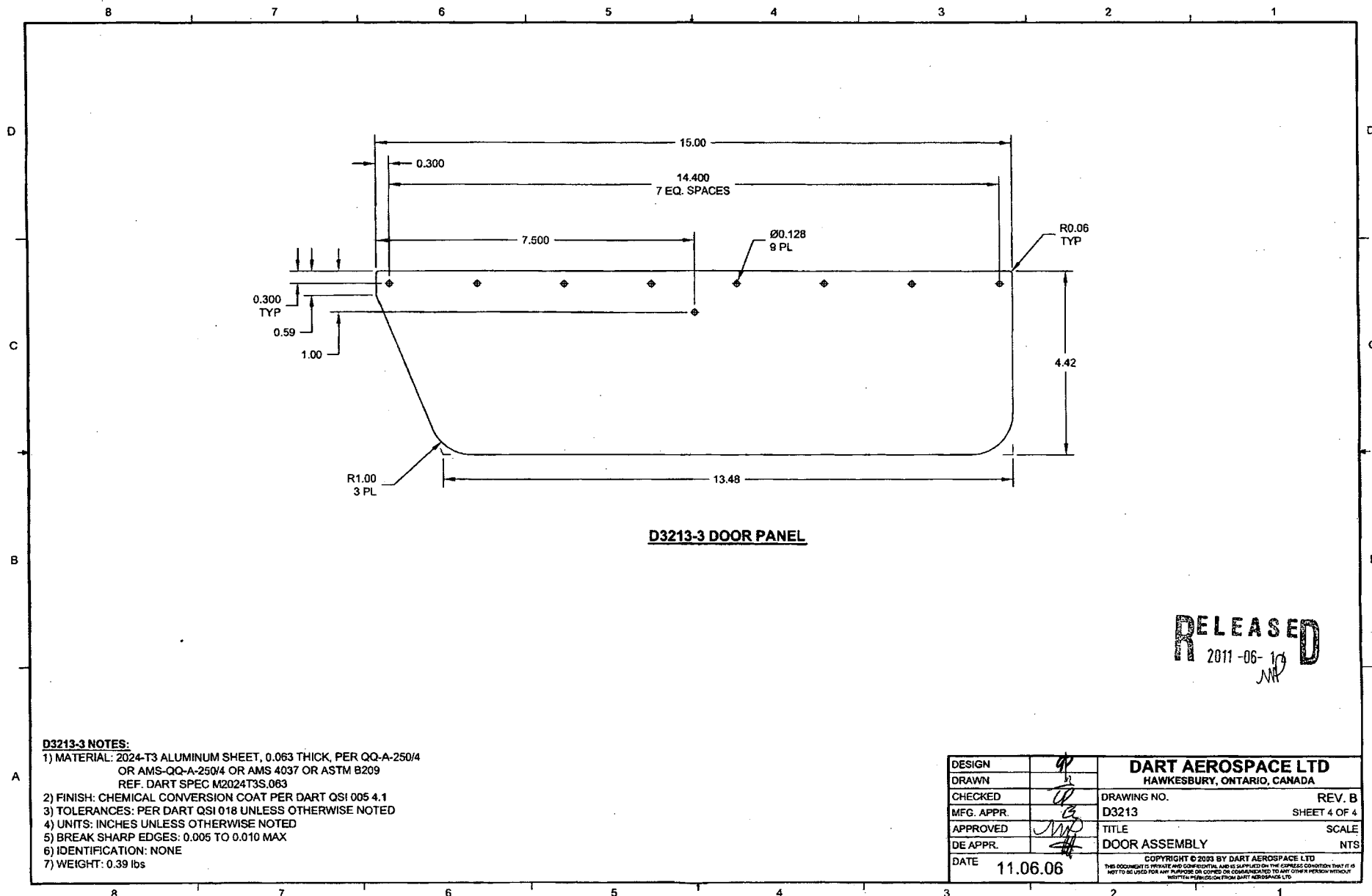
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

74538



RELEASED
 2011-06-10
 JNR

D3213-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.39 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3213	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOOR ASSEMBLY	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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